

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027714**Date Inspected:** 05-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job site**CWI Name:** As Noted Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Ultrasonic Testing OBG (Lift 13 East)

This QA performed 100% Ultrasonic Testing (UT) on a total of two (2) Deck plate longitudinal rib stiffener Complete Joint Penetration (CJP) splice welds at lift 13E. This weld was previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications. The welds are designated as LS13E/14E LS 1 and LS13E/14E LS 2.

(OBG Deck) Lift 6 West

This QA performed 100% Ultrasonic Testing (UT) on a total of one (1) Deck access longitudinal rib stiffener Complete Joint Penetration (CJP) splice welds at lift 6W. This weld was previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. This QA generated a TL-6027 UT report on this date. The weld is designated as 6W PP46.5 W2 LS-W.

During verification Visual Inspection (VT) a total of one (1) linear indication measuring a total of 25mm was observed with residual magnetic particles in way of the rib stiffener cut out termination adjacent the weld being tested (See below photographs). The Smith Emery QC Lead Mr. Bonifacio Daquinag JR. was notified who then

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stated that Caltrans QA would be notified after the indication was ground out and re-inspected.

Tower (ESW Weld Repairs)

This QA observed, at random intervals, ABF/JV qualified welder Xiao Jian Wan #9677 performing Flux Core Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification Specification (WPS) ABF-WPS-D15-3000-3Repair. The joint being welded was tower shear plate designated as ESW weld, location "H" from face B.

Dimensions excavated for this repair were: (Y=7200mm~7530mm)

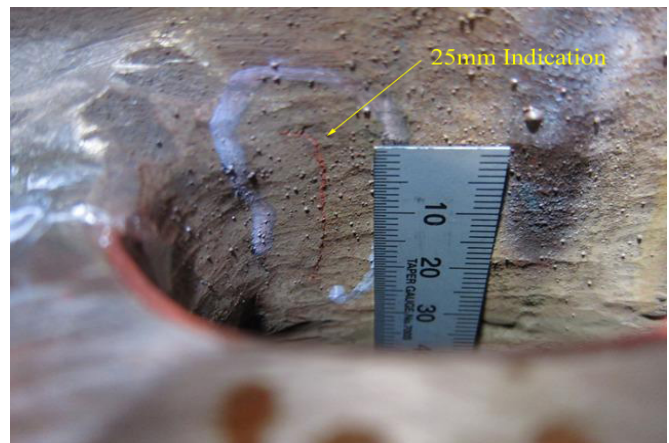
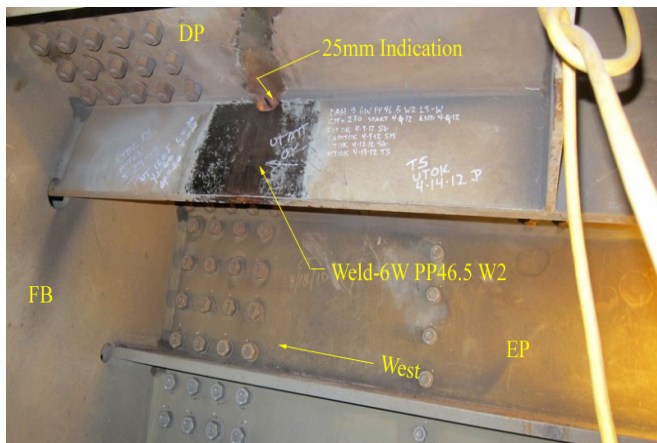
During welding, ABF Quality Control (QC) Jesse Cayabyab was noted monitoring the welding parameters.

Welding parameters were recorded as (A=233, V=22.5).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
